

Date: Monday, 09/02/2009 4:27:15 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: AFT BLADE FOLD ASSEMBLY
<b>Job Number</b>	: 45645		
<b>Estimate Number</b>	: 13532		
<b>P.O. Number</b>	:	<b>Part Number</b>	: PB674300103
<b>This Issue</b>	: 09/02/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: B6743001 P.1,3,4,15
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 43065	<b>Drawing Revision</b>	: B1
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 18/03/2009
		<b>Qty:</b>	2
		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b>	: <u>MF 09-03-03</u>		
<b>Comment</b>	: Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PB674300109	Aft Blade Fold Assembly Weldment
-----	-------------	----------------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Blade Fold Assembly Weldment

batch: \_\_\_\_\_

B 4 5 0 4 7

MF 09-03-10

2.0	PB674300113	Aft Adjustable Blade Support Assembly
-----	-------------	---------------------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: \_\_\_\_\_

B 4 5 0 4 2

MF 09-03-10

3.0	PB674300117	Aft Adjustable Blade Support Assembly
-----	-------------	---------------------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: \_\_\_\_\_

B 4 5 0 4 0

MF 09-03-10

4.0	PB674300121	PB67-43001-21
-----	-------------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-21

batch: \_\_\_\_\_

4 5 0 3 8

MF 09-03-10

5.0	PB674300123	PB67-43001-23
-----	-------------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-23

batch: \_\_\_\_\_

B 4 5 0 3 5

MF 09-03-06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 09/02/2009 4:27:15 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-37

batch: 45029

MF 09-03-06

7.0

PB674300157

Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Stabilizer Arm

batch: 45025

MF 09-03-06

8.0

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-59

batch: 43054 x 1, 45024

MF 09-03-06

9.0

PB674300163

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Assembly

batch: B43053 x 1, \* B 45023

MF 09-03-

10.0

PB6743001135

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Male Eye

batch: 23995A

MF 09-03-04

11.0

PB6743001155

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

batch: B 40577 x 1, 41906 x 1

MF 09-03-04

12.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

batch: 42093

MF 09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 09/02/2009 4:27:15 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



10.000

09.07.18



PK

Comment: Qty.: 54.0000 Each(s)/Unit Total: ~~80~~0000 Each(s)

Bushing

batch: 44977

MF 09-03-04

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

batch: B 40062

MF 09-03-04

15.0

PB6743001305

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bearing

batch: B 41886

MF 09-03-04

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B 42996 x1, B 45309

MF 09-03-04

17.0

D3451043

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B 45308 x1, 42348 x1

MF 09-03-04

18.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Tube Guide

batch: 41347

MF 09-03-04

19.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp

batch: ~~41347~~ B 39964

MF 09-03-04

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-03 PAR #: N/A Fault Category: Prod / FAB LRS NCR: (Yes) No DQA: D Date: 09/03/10  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/03/10

NCR: <u>45645</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-10	13.0	1 - 265 scrap. Drill was clamped to the inside wall; the spring pin was sticking out on the inside R.C. Process	<u>[Signature]</u> 09/03/10	Scrap - replace Qty 1 <u>B 44977</u>	<u>[Signature]</u> 09-03-10	<u>[Signature]</u>	<u>[Signature]</u> 09/03/10	<u>[Signature]</u> 09-03-10

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:16 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Velcro Loop Belt

batch: B39965

mf 09-03-04

21.0

D34491

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pad

batch: B41617

mf 09-03-04

22.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

batch: 45018

mf 09-03-04

23.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: 10935

mf 09-03-04

24.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: m18057 \*

mf 09-03-04

25.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: m18057

mf 09-03-04

26.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Nut

batch: m109282

mf 09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 09/02/2009 4:27:16 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: m108183

mf 09-03-04

28.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

mf 09-03-04

29.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

mf 09-03-04

30.0

NAS43DD368

SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPACER

batch: m109060

mf 09-03-04

31.0

NAS1149F0316P

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: m109031

mf 09-03-04

32.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: m18057

mf 09-03-04

33.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

mf 09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 09/02/2009 4:27:16 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: 18057

MF 09-03-04

35.0

AN960JD6

Washer



Comment: Qty.: 5 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M1039 6085

04.03.18

MF 09-03-04

36.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M107178

MF 09-03-04

37.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M110865

MF 09-03-04

38.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch:                     

or AN415A (see engineering) batch: M110399

04.03.18

MF 09-03-04

39.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M105558

MF 09-03-04

40.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch:                     

or AN6C16A (see engineering) batch: M105831

04.03.18

MF 09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 09/02/2009 4:27:16 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: m18180

*mf* 09-03-05

42.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

RIVET

batch: m109119

*mf* 09-03-05

43.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

cherry rivet

batch: m104214

*mf* 09-03-05

44.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: \_\_\_\_\_

or MS17984C410 (see engineering) batch: m109739

*09.05.10*

*mf* 09-03-05

45.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986

*mf* 09-03-05

46.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

LANYARD

batch: m102812

*mf* 09-03-05

47.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

LANYARDS

batch: m111039

*mf* 09-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 09/02/2009 4:27:16 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

240107

SPRING SLOTTED PIN



cd 24  
ADD 4 TO INVENT  
can. 07.10



Comment: Qty.: ~~18~~ 0000 Each(s)/Unit Total: 18.0000 Each(s)

SPRING SLOTTED PIN

batch:

1850 → 48 m11088 → 6

mf 09-03-05

49.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

DETENT BALL SPRING PLUNG

batch:

m108390

mf 09-03-05

50.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2

242 THREADLOCK batch: m108687

mf 04/03/11  
cd 09-03-11  
(x2)

51.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-11 (2)

52.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPA 45606

09/3/12 (2)

53.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/12 (2)

Job Completion



Add detail A:

09.03.10

mf 09-03-12

ANS26A x2 B m18057 lpl  
NAS149F0532P x 4 B m18057 lpl  
ms2104225 x 2 B m110382 lpl  
ms246945102 x 4 B m14604 lpl  
ms51859-7 x 4 B m106421 lpl 09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

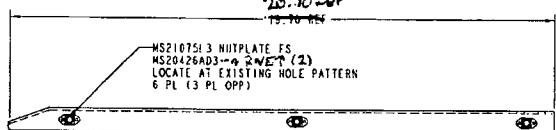
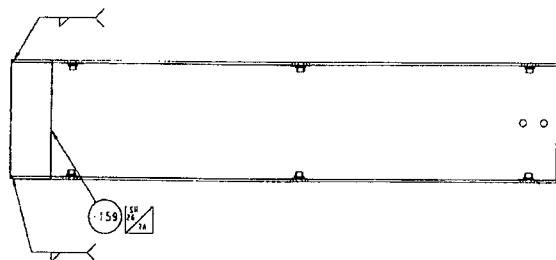
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

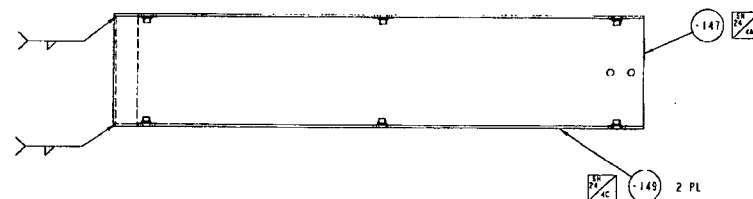
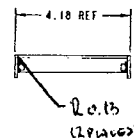


RELEASED  
# 48645



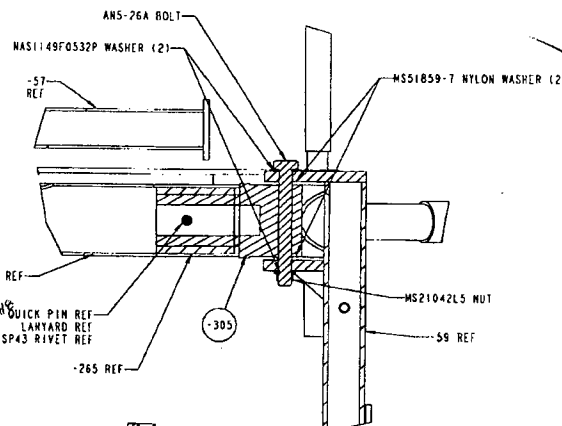
② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



DETAIL A  
SCALE 0.750  
(-03 ASSY)

PREMIER AVIATION, INC.  
2000 Aviation Parkway, Grand Prairie, Texas 75052  
D1033V8 B67-43001

ORIGINAL

